0.00

1311-1-20

Quality Control

120

Quality Control

QC8- Inspect parts - second check

Memo

Memo

	•								_		
W/O:			WO	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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						i i					
Part No:		PAR #:	Fault Categ	ory:	NCR: Yes No DQA: Date:						
Resolution:			Disposition	QA: N/C	QA: N/C Closed: Date:						
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NO	CR)					
DATE	0750	Description of NC		tion B	Ve	rification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sig Da	n& s	ection C	Chief Eng	QC Inspector		
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- 											

Work Order ID 65076

Thursday, January 06, 2011 9:10:54 AM



Page 2

Item ID:

D3278-3

Accept



Setup Start

Stop



Revision ID:

Start Date:

Item Name:

Spacer

Start Oty: 40.00 1/6/2011

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Reg'd Oty: 40.00

Date:

Tooling:

Date:

Run Start

Reject

Oty

Required Date: 1/13/2011

OC:

Operation

Description

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

130

Small Fab Small Fab

Small Fab

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

1-C'sink as per dwg D3278 □ 2-Deburr

Tool ID

Tool # Plan Code

Accept Oty

Reject Number

Insp. Stamp

140

OC

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location Smal FAB

150

Packaging Packaging

Memo

0.00

11/1/26 St

Dart A	erospace	Ltd
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Dail / (O	OSpace	Liu										
W/O:			W	ORK ORDER CHANG	ES							
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No:		PAR #:	Fault Cat	egory:	NCR: Yes No DQ			QA: Date:				
Resolution:			Dispositi	on:	_ QA:	N/C Clo	sed:		Date: _			
NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC Section A	Corrective Action Initial Action Descr Chief Eng Chief Eng		Section B tion Sign & Date		Verification Section C		Approval Chief Eng	Approval QC Inspector		
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]			

Work Order ID 65076

Thursday, January 06, 2011 9:10:54 AM



Page 3

Item ID:

D3278-3

Accept



Setup Start



Revision ID:

Spacer Item Name:

Required Date: 1/13/2011

1/6/2011 **Start Date:**

Start Qty: 40.00

Req'd Qty: 40.00



Cust Item ID:

Customer:

Reference:

Approvals:

QC:_

Process Plan:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date: ____

Start

Stop



Stop

Sequence ID/

Work Center ID

160

Description

Operation

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code

Reject Accept Qty Qty

Run

Reject Number

Insp. Stamp

Memo

0.00

Quality Control

	TOPATO								_				
W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:	Fault Categ	ory:	NCR: Yes No			DQA: Date:					
Resolution:								Date: _					
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NC	R)							
DATE	CTED	Description of NC	Corrective Action		Section B V		fication	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat		ction C	Chief Eng	QC Inspector				
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Picklist Print

Thursday, January 06, 2011 9:10:58 AM

Work Order ID: 65076

Parent Item: D3278-3

Parent Item Name: Spacer



Start Date: 1/6/2011

Required Date: 1/13/2011

Page 1

Start Qty: 40.00

Required Oty: 40.00

Comments:

IPP . A□ 04.04.19□New issue□KJ/JLM□

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINS0.125		Purchased	No			110	sf	0.8887	0.0344	1.448421			
										ıΣ	11-1-20		

Black Delrin Sheet .125

Location Loc Oty Loc Code MAT 0.8887 101657 0.8887

101657

W/O:			WO	RK ORDER CHANG	ES				`		
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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						, , , , , , , , , , , , , , , , , , ,			-		
		PAR #:	Fault Category: NCI			NCR: Yes No DQA: Date:					
		esolution:	Disposition		_ QA: N/C C	losed:		Date: _			
NCR:				R NON-CONFORM		R)					
DATE	STEP	Description of NC	Corrective Action		V		Verification App		Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Date		tion C	Chief Eng	QC Inspector		

DART AEROSPACE LTD	Work Order: 450	74
Description: Spacer	Part Number: D3278	1-3
Inspection Dwg: D3278 Rev: C	Page 1	of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.98(7		V BOZ	
1.98	+/-0.030	1.980	>		V	
1.480	+/-0.005	1.499	`		V	
0.250	+/-0.010	-249	<u>></u>		V	
1.480	+/-0.005	1.479	کیز		V	
0.250	+/-0.010	749	*		V	
Ø0.098	+0.005/-0.000	, 100	>		V	
R0.13	+/-0.030	.13			R.G.	
0.125	+/-0.010	861,	>		V	
,						

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-1-30	Date: 11/01/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.02.02	Dwg updated per JLM	KJ/JLM	
D	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	B
	*		· · · · · · · · · · · · · · · · · · ·	

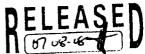
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DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No:		PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
	Resolution:		Disposition:	QA: N/C Closed	d:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Approval QC Inspector		
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C				
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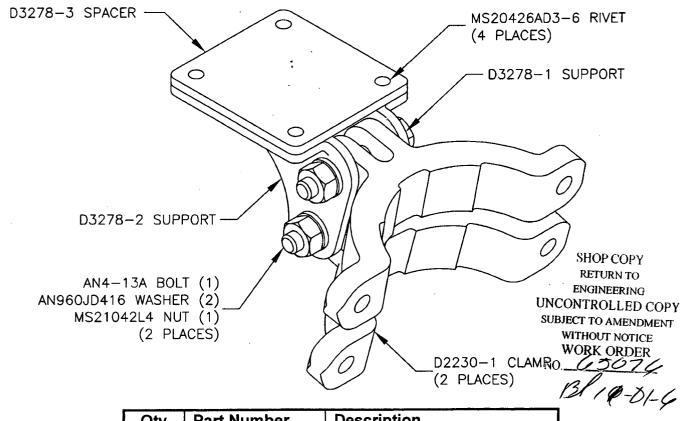


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ı		4	4	#	D3278	SHEET	1 OF	3
Ī	DATE				TITLE		SCA	NE.
	07.0	07.24	-		SUPPORT ASSEMBLY		1	ŧTS
	Α			04.03.03	NEW ISSUE			
	В			05.03.31	CHANGE DIM/TOL TO ENSURE	FIT		
Γ		Ī			24444255 201550 252 242 114	0.5		



C | 07.07.24 | CHANGED RIVETS PER PAR #185

D3278-041 SUPPORT ASSEMBLY

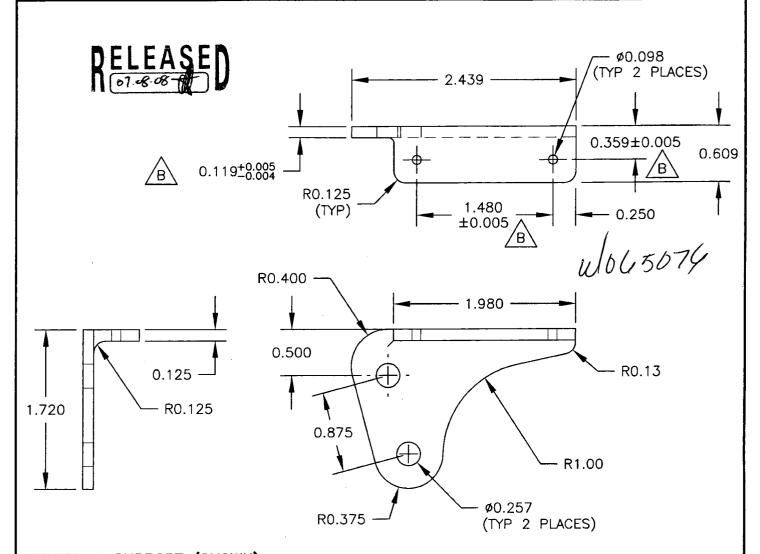


Qty	Part Number Description	
Х	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DATE	STEP	PROCEDURE CHANGE				Date (Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No):	PAR #:			NCR: Yes	No DQA :		_ Date: _	
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DATE		TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1.



D3278-1 SUPPORT (SHOWN) D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR

PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)

PER AMS-QQ-A-200/8 (OR AMS 4160)

(REF. DART SPEC. M6061T6B)

- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:			W	ORK ORDER CHANGE	Ŝ				
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No)2	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:	1
			Disposition: Q						
NCR:			WORK ORD	DER NON-CONFORMAL	NCE (NCF	R)			
DATE	STEP	TED Description of NC	Corrective Action Section B				cation	Approval Chief Eng	Approval QC Inspector
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	ion Description Sign & Date		Section C		
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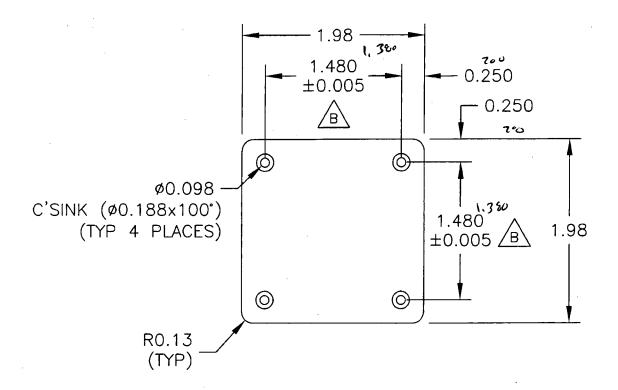
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DATE	· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1



ul045074



D3278-3 SPACER

1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR

DELRIN II 150E OR ACETRON GP ACETAL

(REF. DART SPEC. M-DELRIN-S.125)

- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution:		esolution:	Disposition:			QA: N/C Closed:			Date:		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCF	₹)					
DATE	STEP	Description of NC			on B		cation	Approval	Approval		
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